

Wednesday, 17/09/2008 3:56:37 PM
Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
 Job Number : 42079
 Estimate Number : 13582
 P.O. Number :
 This Issue : 17/09/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : SMALL /MED FAB
 Previous Run :
 Written By : 08-09-17
 Checked & Approved By :
 Comment : Est Rev:A New Issue 08-09-17 JLM Verified By:EC

Part Number : D38201
 Drawing Number : D3820 PREL
 Project Number : N/A
 Drawing Revision : PREL
 Material :
 Due Date : 24/09/2008 Qty: 3 Um: Each

FOR ESTIMATION USED

proto u

Additional Product

PRELIMINARY ISSUEPOSITIVE
RECALL

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet

*IS MAT NOT PULLED*

Comment: Qty.: 0.0543 sf(s)/Unit Total: 0.1629 sf(s) *IB 8-10-2*
 6061-T6 .125 Sheet *108730 IB 8-9-29*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3820

*IB 8-10-2*Dwg Rev: *PRE L.**IB 8-9-29*Prog Rev: *PRE L.**IB 8-10-2*

2-Deburr if necessary

*IB 8-9-29***(3)**

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

*IB 8-10-2**IB 8-9-29*

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08-10-01 (3)
08-10-02 3

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3820

*SB 08/10/03***(3)**

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 42079

Part Number: D38201

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



08.10.06 (3)



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/10/06 (3)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

N/A u per Prod 08.10.03

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



HARLEY -> Eagle.



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

AS 08/10/06 (X3)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE

RELEASED

AUTH

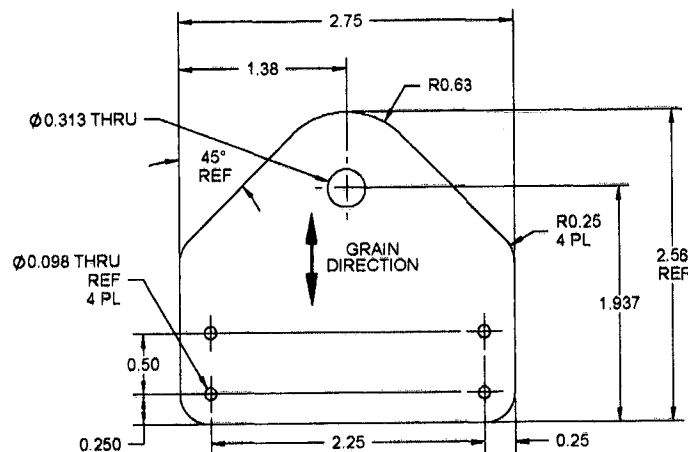
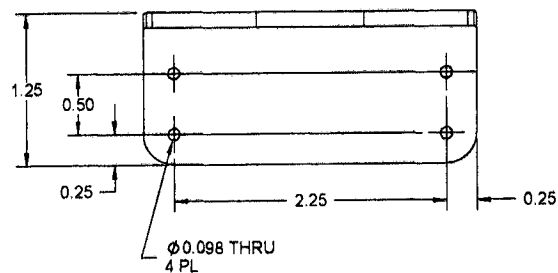
DATE

00252A

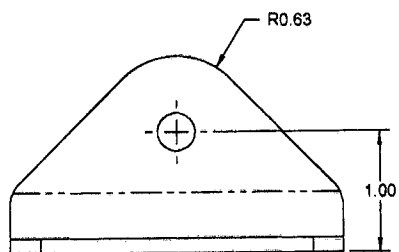
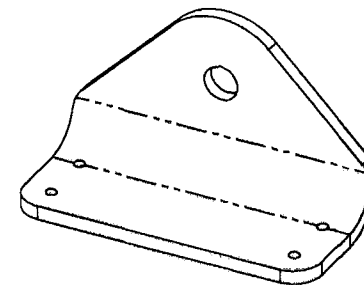
u 08.10.06

u

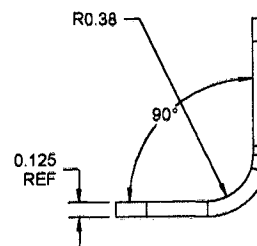
3 parts scrap due to we did not have.
1/4" die, Evg changed to .375
Paul.



D3820-1F BRACKET FLAT PATTERN



D3820-1 BRACKET
(MADE FROM D3820-1F)



NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET X 0.125 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3820-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs

REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.10.02			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO.	D3820	SHEET 1 OF 1
TITLE	BRACKET	SCALE NTS

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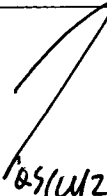






PRELIM ISSUE

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-10-06	8.0	3 parts scrap. - Parts did not meet the dwg due to incorrect die's being used. Dwg asked for R.250", and a R.3/8 was used, and also identified as a 1/4" die. R.C. Tools are not identified correctly, and are clearly not measured to ensure the tool is the correct size.		Scrap: replace 2x sets of 3.	 8-10-06	 08-10-06	 08/10/06	 10-10-06
				Ensure all tools and material are measured prior to use, regardless of the identification.	 08/10/06	 08-10-06	 08/10/06	 10-10-06

NOTE: Date & initial all entries

